

Date: Tuesday, 16/12/2008 2:13:19 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 44126		
Estimate Number	: 11683		
P.O. Number	:	Part Number	: D2888
This Issue	: 16/12/2008 S.O. No. :	Drawing Number	: D2888 REV A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 42714	Material	:
Written By	:	Due Date	: 30/12/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JL 08.12.16</u>		
Comment	: Est. C 00.06.22 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2500X03500	6061-T6 Bar 2.50 x 3.50
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Comment: Qty.: 0.3938 f(s)/Unit Total : 3.9375 f(s)
 6061-T6 Bar 2.5" x 3.5"
 Material: 3.5" x 2.5" bar 6061-T6

Batch M105212JL 08/12/23

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 4.20" long
 (Grain along 4.20")

JL 08/12/23

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2888
 Deburr and Tumble

JL 08/12/28

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/12/28

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 08/12/28 (16)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2888 PAR #: NA Fault Category: Prod/Machined Parts NCR: (Yes) No DQA: LD Date: 09/01/15
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: LD Date: 09/01/15

NCR: <u>44126</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/27	3.0	- part is scrapped - operator took bad origin * operator error	<u>/08/14/12</u>	- scrap + replace <u>B M105212</u>	J.L 08/12/28	<u>/08-01-05</u>	<u>/08/14/12</u>	<u>/09-01-05</u>

NOTE: Date & initial all entries

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Drawing Name: LUG

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Part Number: D2888

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(10x)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.A

08/12/30

7.0

POWDER COATING

POWDER COATING



M109996



(10x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:00

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:30

M.A

08/12/30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(10)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/12/30

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(10x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

970

8/12/31

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

09/01/05

Job Completion



MF 08-12-31

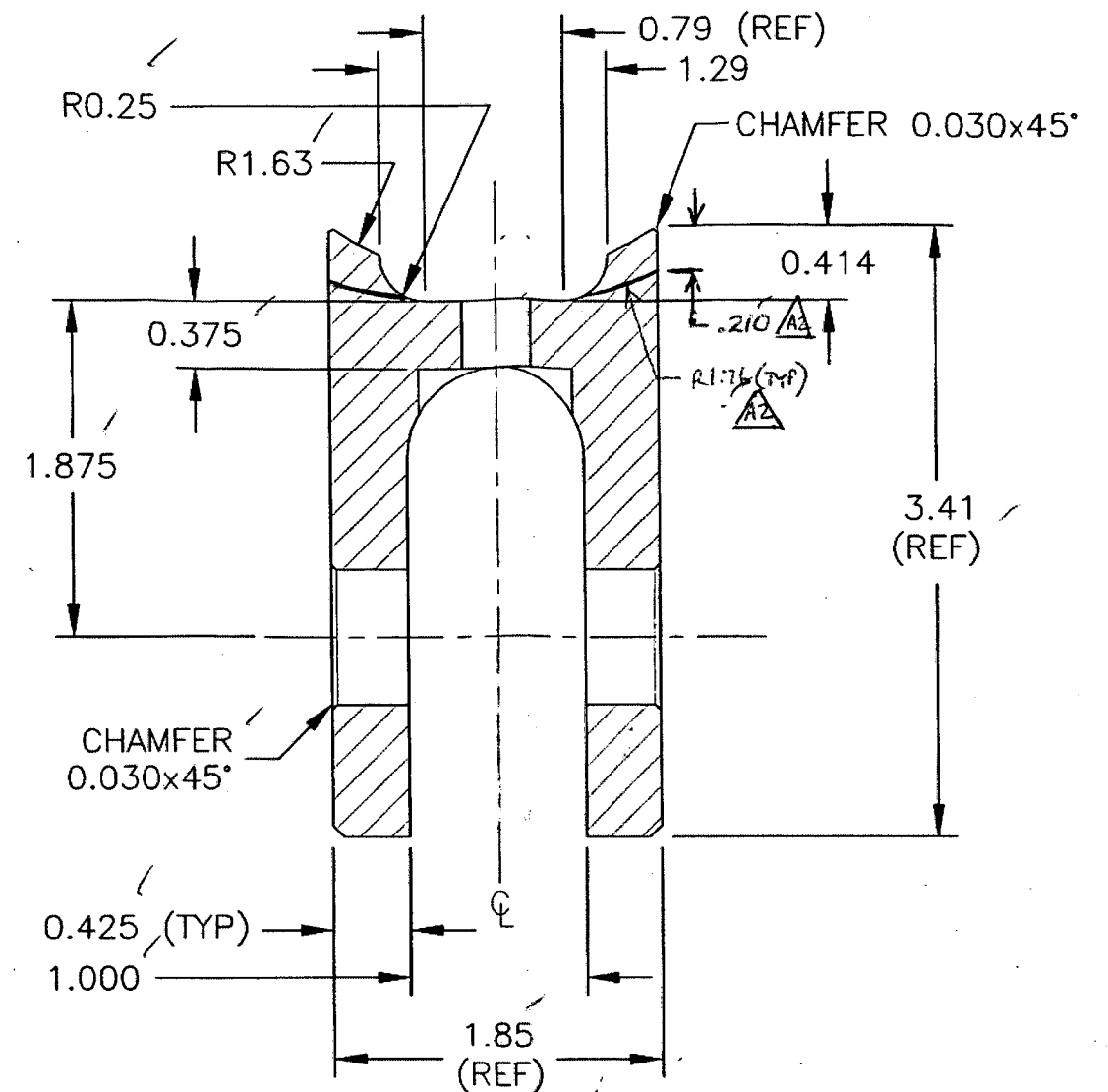
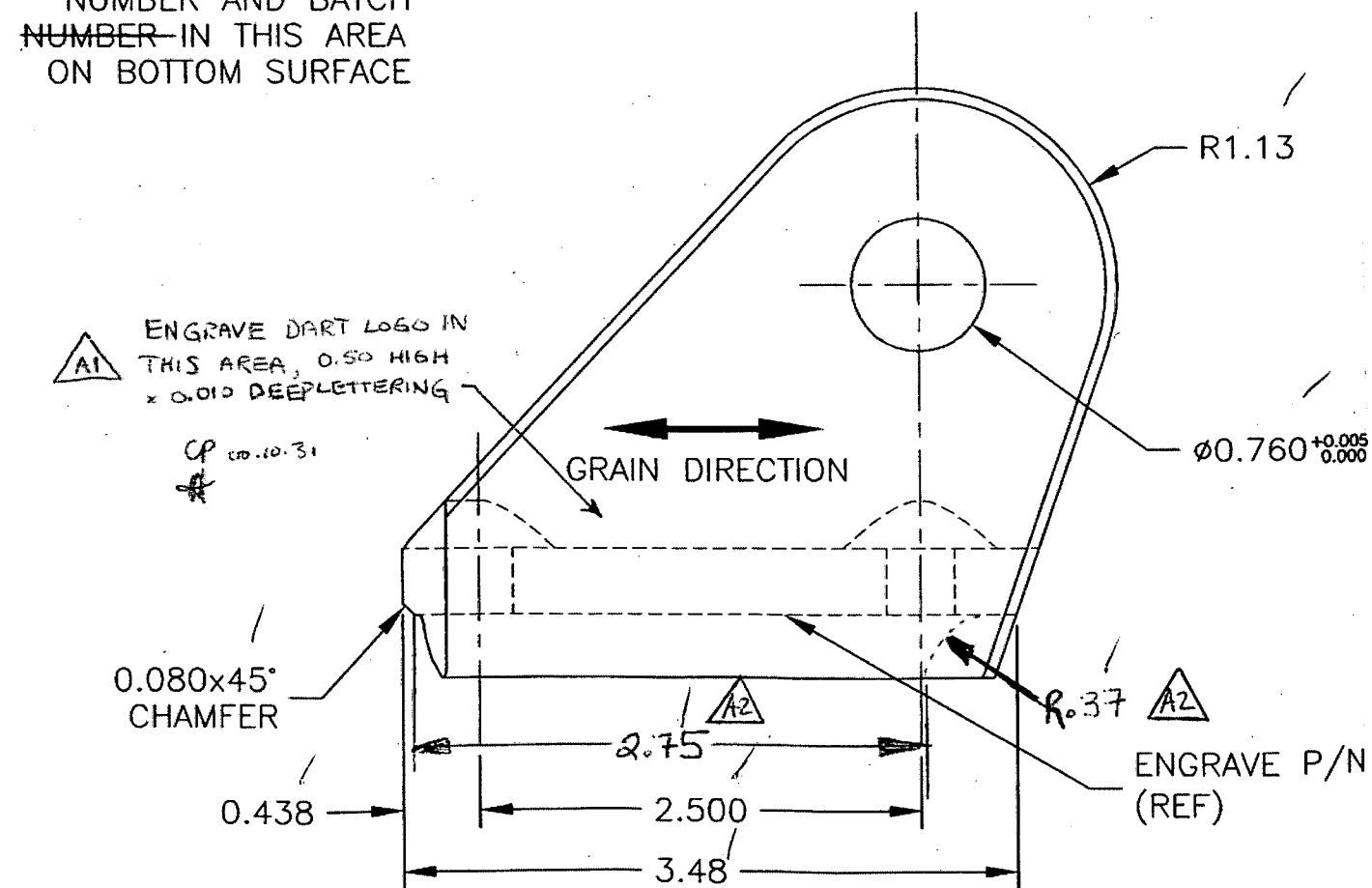
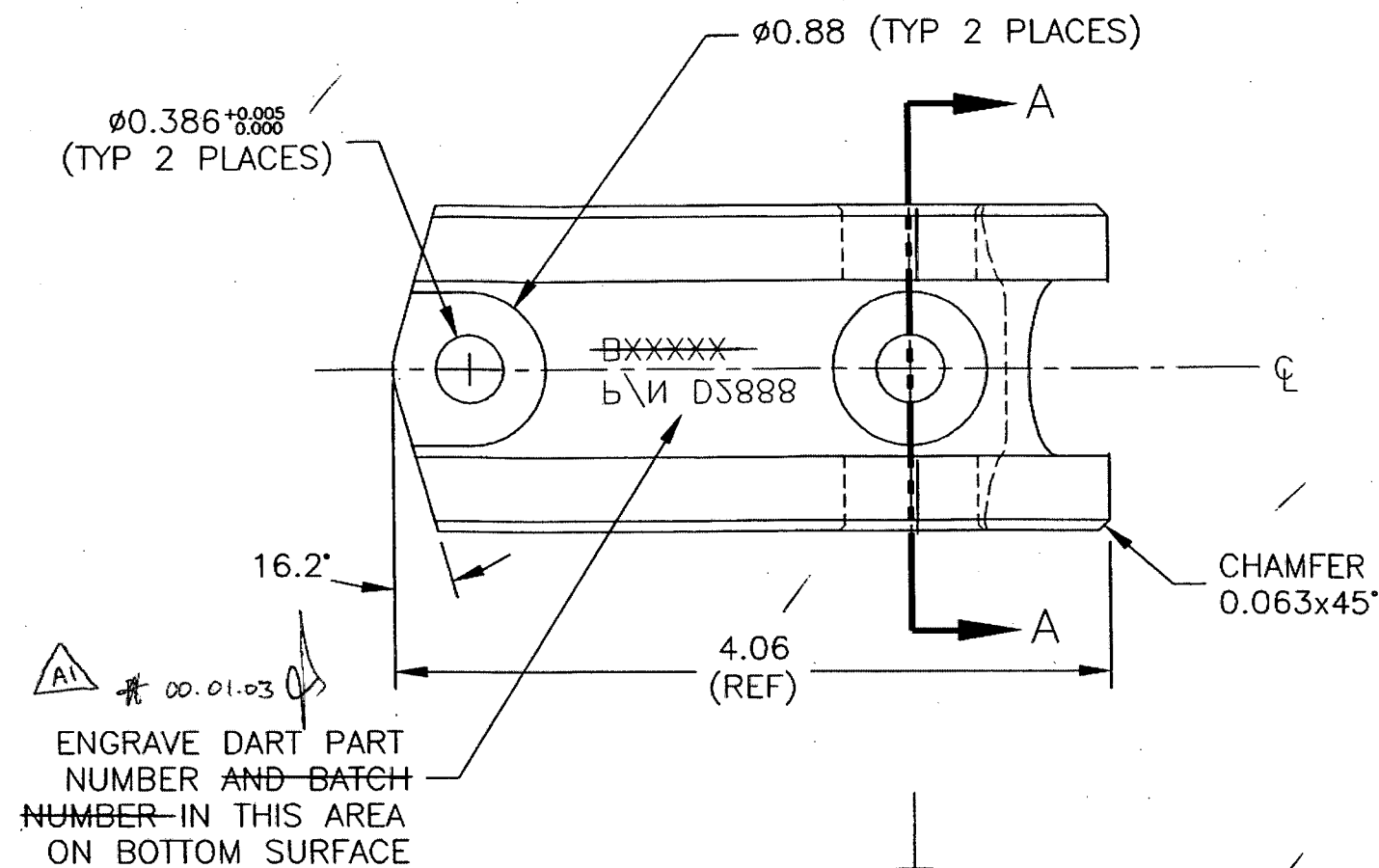
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A
SCALE 1:1

RELEASED
99.07.09 DS
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 141/21

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A	99.06.21	NEW ISSUE	
DESIGN	DRAWN BY	DART	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
A2	04.04.08	D2888	SHEET 1 OF 1
A1	00.10.31	LUG	SCALE
	99.06.21		1:1

DART AEROSPACE LTD		Work Order: 44126
Description: lug		Part Number: D2888
Inspection Dwg: D2888 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.386	+ .005 - .001	.387	✓			
.88	+ .030 - .030	.880	✓			
4.06	+ .030 - .030	4.060	✓			
.063X45°	+ .010 - .010	.053X45°	✓			
.080X45°	+ .010 - .010	.084X45°	✓			
.438	+ .010 - .010	.438	✓			
2.500	+ .010 - .010	2.500	✓			
3.48	+ .030 - .030	3.483	✓			
1.37	+ .030 - .030	.375	✓			
Ø.760	+ .005 - .005	.764	✓			
1.25	+ .030 - .030	.250	✓			
.375	+ .010 - .010	.370	✓			
1.875	+ .010 - .010	1.885	✓			
.03X45°	+ .010 - .010	.025X45°	✓			
.425	+ .010 - .010	.420	✓			
1.000	+ .010 - .010	1.005	✓			
1.85	+ .030 - .030	1.844	✓			
3.41	+ .030 - .030	3.395	✓			
.210	+ .010 - .010	.205	✓			
.414	+ .010 - .010					
1.29	+ .030 - .030	1.289	✓			
.79	+ .030 - .030	.780	✓			

Measured by: JL	Audited by: [Signature]	Prototype Approval: N/A
Date: 08/12/27	Date: 08/12/29	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	